•		· · · · · · · · · · · · · · · · · · ·	<u>-</u>							Fra	
Work Orde Tuesday, August		· -		*10	5826	· ·			Ship	Au	Page 1
Revision ID:	D2005-011		 	Accept	ากก4	010	n* s	Setup Star Stop	171	S1* S2*	
Start Date: 8 Required Date: 8 Reference:	8/20/2013 8/30/2013	Start Qty: 2.00 Req'd Qty: 2.00	*2°		Cust I	tem ID: ner:				14	(1)
Approvals:	Process Plan	n: 1M-	Date: 13-8			Date:		R	tun Star	' *N	R1*
	QC:	· —- · —— ·	Date:	SPC (Y/N):		Date:			Stop	` *N	R2*
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool	ID Too	l# Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr									
D2005-011	Rev	c									
100	. ,		·	0.00				•			==
100 Small Fab		Small Fab		0.00		•		_2	Ø		13-08-2
Small Fab		Press fit D20 Note:(15° c	hamfer towards insid tor in place using cle	er Dwg. D2005-011 place as per Dwg. D2005-01		***				F	
*110 *2110*		QC5- Inspect part comple	cteness to step on W/	_	nb		• • • •	9			·

DQA:	Date:	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

IVCIX.	es / NO				WORK ORDER HORE		J111	MARIOL / OT		QA Closed:	Date:		
Work Orde	r:				DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS		
Part N					Rework Scrap		Skid-tube Crosstu Machining Small F				Water Jet d. Eng. Coor.	Engineering Quality	
NCR N	o			• • • • • • • • • • • • • • • • • • • 	Use-as-is Work Order Update]	Thermoforming Finishi Large Fab Compos			-			
Root				Descri	ption of work order update	Initi	al	Act	tion	Sign &			
Cause	Date	Step	Qty	(or Non-conformance	Chief	Eng	Desci	ription	Date	Verification	QC Inspector	
Doc/Data													
Equip/Tooling		1											
Operator [İ											
Material [
Setup													
Other													
Process	_												
Supplier	_	•											
Training		j				ŀ							
Unapproved		<u> </u>											
						AULT C	ATE	GORY				<u> </u>	
Landir	g Gear				General					1	_	٦. ، ،	
ŀ	Bending	_		-	Bend	Gra			<u> </u>	Ovalized	<u> </u>	Pressure/Forced	
	Centre N	ot Conce	ntric to (^{D/S} -	BOM/Route	\mathbf{H}	rdwa		<u> </u>	Over/Under		Temperature/Cure Weld	
	Cracks	·		-	Broken/Damaged	_		on incomplete		Part Incorre		Wrong Stock Pulled	
	_ `	Crushed/Crimped			Burrs	$\boldsymbol{\vdash}$		ions Incomplete/	Unclear	Part Lost/M Part Moved	issing	Twioug stock rulled	
}		Cuffs			Contamination	1	ante slabe	nance	-	Positioned V	Mrong		
}	Heat Treat Inspection Strip in Tube			<u> </u>	Countersink Cut Too Short	\vdash	sreac		<u> </u>	Power Loss/		Other	
ŀ	Ripples in	-	iube	\vdash	Drill Holes	\vdash	set	•	<u></u>	J. OWEL E033/	50.8e	Total Car	
	Torque V		Evtrucion	, ⊢	Drawing	\vdash		Calibration		-			
	Turning S			·	Finish	—		Sequence					

Outside Dimensions

Wave/Twist in Tube

Folio

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Work Ord Tuesday, Augus					Page 2							
Item ID: Revision ID:	D2005-011			Accept	*N9(1 900040100			Setup Sta	I/I	S1*	
Item Name: Start Date: Required Date: Reference:	Restrictor Ell 8/20/2013 : 8/30/2013	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust It Custon				Sto	^р *N	S2*	
Approvais:	Process Pla	an:	Date:	Tooling:		Date:		1	Run Sta Sto	<i>"IM</i>	R1*	
	QC:			SPC (Y/N):	· ·	Date:	-		510	* *N	R2*	
Sequence ID/ Work Center II 120	D	Operation Description Identify as per dwg & St	ock Location: STO	Set Up/ Run Hours	Tool	ID Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
120 Packaging Packaging		Мето		0.00				_X <u>_</u> C_	·		13-8	-3
130		QC21- Final Inspection -	Work Order Release	0.00								
130 QC QC Quality Control		Мето		0.00				M_0	~ 5		-28	

\$13.08.7d

NCR:	Yes /	No No	WORK ORDER NON-CONFORMANCE / UPDATE

Folio

												DQA:	Da	te:	
NCR:	'es	/ No					WORK ORDER NON-C	O	VFOR	MANCE / UPI	DATE	QA Closed:	Da	te:	
Work Orde							DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part N	Part No						Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier			Engineering Quality Other	
Root Cause		Date	Step	Qty	Des		tion of work order update or Non-conformance		nitial ief Eng	Act	ion iption	Sign & Date	Verificatio	n	QC Inspector
oc/Data quip/Tooling perator flaterial etup ther rocess upplier raining															
				1	<u> </u>		F	AUL	T CATE	GORY		<u> </u>	 		
Landi	ng G	iear				-	General	HOL	CATE						
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion					Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset Out of Calibration			Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	
	Turning Sequence Finish						Finish		Out of 9	Sequence					

Outside Dimensions

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Wave/Twist in Tube

Page 1

Work Order ID:

105826

Parent Item:

D2005-011

Parent Item Name:

Restrictor Elbow

Start Date: 8/20/2013

Required Date: 8/30/2013

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP B99.08.24Re-formatDM/EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Date Status Issued Issued
D2005-003 Restrictor	,1	Manufactured	No			100	Each	18.0000	1	2	FF 13-00-27
				Location Mezz.	<u> </u>	<u>Loc Oty</u> 18 18	Loc	c Code		2_	
AN833-8J Elbow,Bulkhead-M-Flare		Purchased	No			100	Each	6.0000	1	2	FF 13-00-27
				Location		Loc Oty	Loc	c Code			
				ST325		6					
				1077	36	6				2	

										DQA:	Date:		
NCR: Yes /	No No				WORK ORDER NON-	CON	FORM	MANCE / UF	PDATE	QA Closed:	Date:		
Work Order:					DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part No. NCR No.				Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
Root		ı		Descri	ption of work order update		nitial		ction	Sign &			
Cause	Date	Step	Qty	(or Non-conformance	Chi	ef Eng	Des	cription	Date	Verification	QC Inspector	
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved		u		·	·		r cate	CODY					

Landing G	iear	General				_	
	Bending	Bend		Grain	Ovalized		Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware	Over/Under tolerance		Temperature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete	Part Incorrect		Weld
	Crushed/Crimped	Burrs	Г	Instructions Incomplete/Unclear	Part Lost/Missing		Wrong Stock Pulled
	Cuffs	Contamination		Maintenance	Part Moved		
	Heat Treat	Countersink		Mislabeled	Positioned Wrong		_
	Inspection Strip in Tube	Cut Too Short		Misread	Power Loss/Surge		Other
	Ripples in Bend	Drill Holes	Г	Offset			
	Torque Waves in Extrusion	Drawing		Out of Calibration			
	Turning Sequence `	Finish		Out of Sequence			
	Wave/Twist in Tube	Folio		Outside Dimensions			

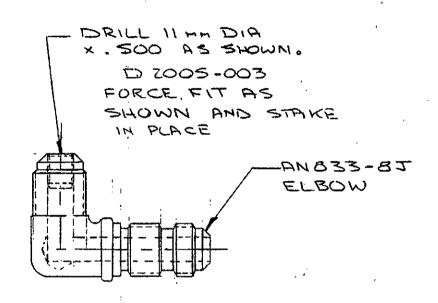
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DESIGN BRA	DLBY	BRACKET	DART AEROSPAC	E LTD
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DATE	ے . ح	4.17	RESTRICTOR	FLEOW
	RE	HWASE.	96.04.17 9	

RELEASED



DETAIL OF D2005-011

										DQA:	Date	
NCR: Y	es / No				WORK ORDER NON-C	ON	NFORM	MANCE / UP	DATE	QA Closed:	Date	:
					DISPOSITION				AGAINST DE			
Work Orde					Rework Scrap Use-as-is		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing			4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR No.					Work Order Update			Large Fab	Composite	116675101	Supplier	
Root Cause	Date	Step	Qty		ption of work order update	1	nitial ief Eng		tion ription	Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved				·			·	•				
						AUL	T CATE	GORY		<u>-</u>		
Landi	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend				General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset			Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing Vrong .	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled .
	Torque Waves in Extrusion				Drawing	Out of Calibration						

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish Folio